

Work Order ID 79417

79417

Page 1

January-26-12 7:27:47 AM

Item ID: D2596

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 1/26/12 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/27/12 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan:  Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2596	Rev D

100	Skidtubes	0.00
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100
Skidtubes
Skidtubes

Memo

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

110	Chemical Conversion Coat per QS1005 4.1	0.00
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
110
HandFinish
Hand Finishing

Memo


120	QC5- Inspect part completeness to step on W/O	0.00
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120
QC
Quality Control

Memo

(4)  CF 12-1-26

(4)  CF 12-1-26

 12-1-26

January-26-12 7:27:47 AM

79417

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Web, 205 Skidtube

Start Date: 1/26/12 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/27/12 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

④ ~~Q~~ CF 12-1-26
~~IV~~
 12/1/26 HJ
 MF
 12-01-26

Picklist Print

January-26-12 7:27:47 AM

Page 1

Work Order ID: 79417

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 1/26/12

Required Date: 1/27/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 Ext'n - I' Beam Web 4"		Manufactured	No			100	Each	24.0000	1	4			

Location

Loc Qty

Loc Code

LG

24

51957

2

66298

22

(4)

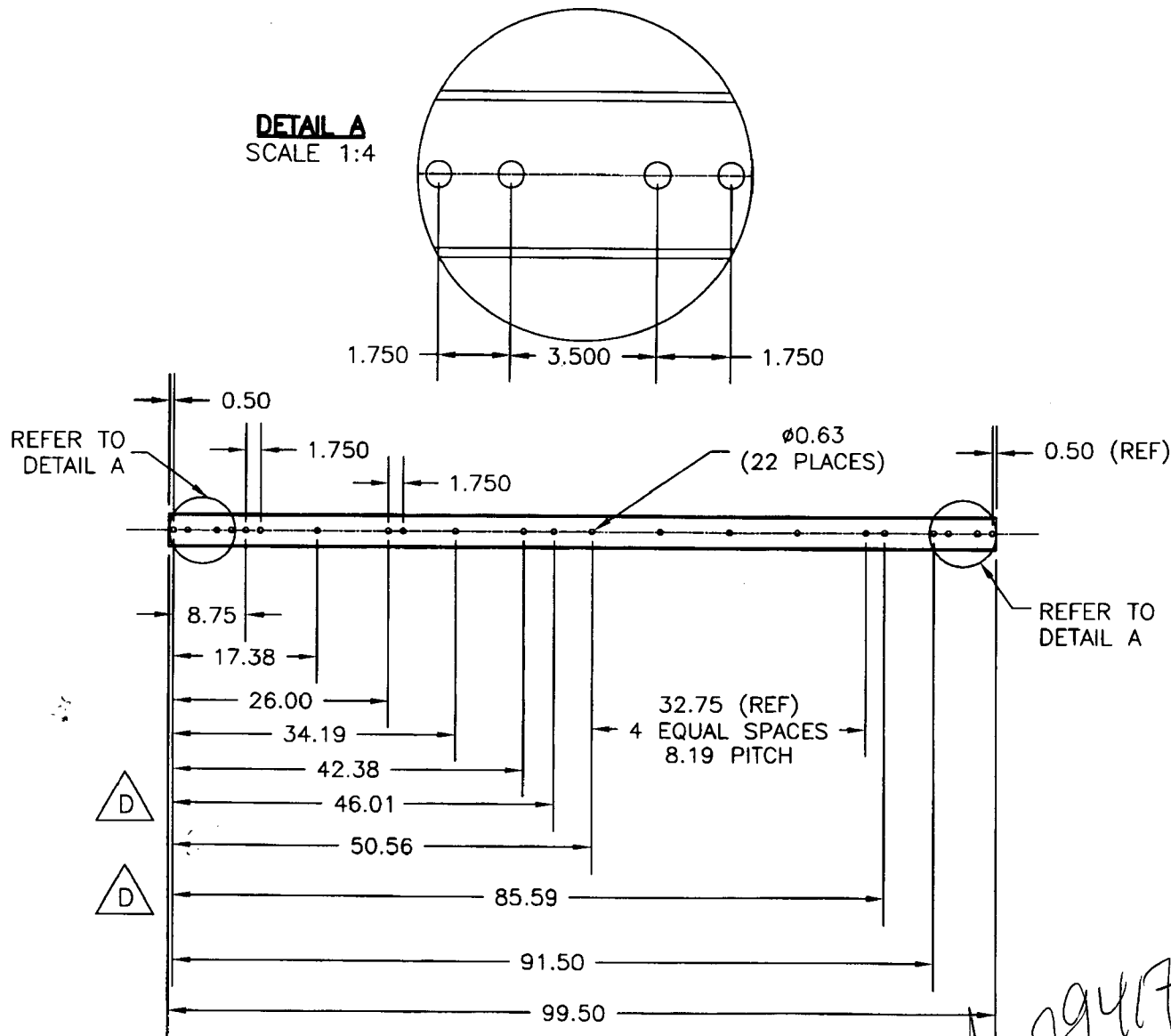
12-1-26

DART

RELEASED
07.06.68

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. D
84	84	DRAWING NO.	D2596	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	205 WEB	SCALE
07.04.17				1:20
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

